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**D2438****Job Sheet 205192****Part No:** D2438**Job Qty:** 40 pcs**Part Name:** Clamp**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/2/20**Job Tracking No:****Due Date:** 2/27/20**Created By:** Kimberley Guerin**Type:** Stock**Description:****Note:** DWG D2727 REV A1, D2438 REV C IPP: E 05.06.28 Bending removed KJ/JLM**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation           | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                     |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Flow - 1 | 40 pcs |            | 2/27/20  | 0.17      | 1.41    | Waterjet - Flow       |           | OK 20/03/21 |
| 120   | QC 8                | 40 pcs |            | 2/27/20  | 0.00      | 0.00    | QC 8 - 12             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 14             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 17             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 20             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 25             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 3              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 32             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 33             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 35             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 39             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 4              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 44             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 45             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 49             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 58             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 8              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 9              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 68             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 67             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 1 (A)          |           |             |
|       |                     |        |            |          |           |         | QC 8 - 47             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 40             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 52             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 23             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 57             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 76             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 61             |           |             |
| 130   | Small Fab - 2 - B4B | 40 pcs |            | 2/27/20  | 0.00      | 1.38    | Small Fab - 1 - B4B   |           |             |
|       |                     |        |            |          |           |         | Small Fab - 2 - B4B   |           |             |

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|                                 |                         |         |           |  |                             |                   |                                                                                    |
|---------------------------------|-------------------------|---------|-----------|--|-----------------------------|-------------------|------------------------------------------------------------------------------------|
|                                 |                         |         |           |  | Small Fab - 3 - B4B         | APR 23 2020       |  |
|                                 |                         |         |           |  | Small Fab - 4 - B4B         |                   |                                                                                    |
|                                 |                         |         |           |  | Small Fab - 5 - B4B         |                   |                                                                                    |
|                                 |                         |         |           |  | Small Fab - 6 - B4B         |                   |                                                                                    |
|                                 |                         |         |           |  | Small Fab - 7 - B4B         |                   |                                                                                    |
|                                 |                         |         |           |  | Small Fab - 8 - B4B         |                   |                                                                                    |
|                                 |                         |         |           |  | Small Fab - 9 - B4B         |                   |                                                                                    |
|                                 |                         |         |           |  | Small Fab - Various 1 - B4B | GP 20-04-24.      |                                                                                    |
| 140 QC 5                        | 40 pcs                  | 2/27/20 | 0.00 0.00 |  | QC 5 - 10                   | APR 24 2020       | DAS<br>40<br>9-89                                                                  |
|                                 |                         |         |           |  | QC 5 - 12                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 17                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 18                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 19                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 22                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 24                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 3                    |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 43                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 49                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 51                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 58                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 68                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 9                    |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 50                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 30                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 40                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 61                   |                   |                                                                                    |
|                                 |                         |         |           |  | QC 5 - 81                   |                   |                                                                                    |
| 150 Packaging 3-1 - Stock - B4B | 40 pcs<br>48 pcs<br>MHD | 2/27/20 | 0.00 0.00 |  | Packaging 3 - 1 - B4B       | DAS<br>28<br>9-89 |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 2 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 3 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 4 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 5 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 6 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 7 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 8 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 9 - B4B       |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 10 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 11 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 12 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 13 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 14 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 15 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 16 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 17 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 18 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 19 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 20 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 21 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 22 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 23 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 24 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 25 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 26 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 27 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 28 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 29 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 30 - B4B      |                   |                                                                                    |
|                                 |                         |         |           |  | Packaging 3 - 31 - B4B      |                   |                                                                                    |

|                |           |         |           |                        |                 |
|----------------|-----------|---------|-----------|------------------------|-----------------|
|                |           |         |           | Packaging 3 - 32 - B4B |                 |
|                |           |         |           | Packaging 3 - 33 - B4B |                 |
|                |           |         |           | Packaging 3 - 34 - B4B |                 |
|                |           |         |           | Packaging 3 - 35 - B4B |                 |
|                |           |         |           | Packaging 3 - 36 - B4B |                 |
|                |           |         |           | Packaging 3 - 37 - B4B |                 |
| 160 QC 21 - SA | 40<br>pcs | 2/27/20 | 0.00 0.00 | QC 21 - SA - 21        |                 |
|                |           |         |           | QC 21 - SA - 70        | APR 27 2020 DAS |
|                |           |         |           | QC 21 - SA - 53        | 70              |

Part Op 100 - Cut as per dwg D2438 prog rev: C dwg rev: C

Descriptions: 120 - (QC8- Inspect parts - second check) (6.786" center to center)

130 - (Small Fab) 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

160 - QC21- Final Inspection - Work Order Release)

9-89

## Job BOM

| Part / Item | Component Name     | Quantity           | Operation               | Container          |
|-------------|--------------------|--------------------|-------------------------|--------------------|
| M304S16GA   | 304/316 Sheet .063 | 1.6000 sf (.04 ea) | 100-Waterjet - Flow - 1 | S247303<br>S257458 |

## Job Allocations

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Waterjet - Flow - 1 | M304S16GA      | 2        | 292       | 0         |

## Part Specifications

| Spec No | Description | Target/Tolerance                  | Limits         | Type | Special Comments |
|---------|-------------|-----------------------------------|----------------|------|------------------|
| 1       | Clamp       | 0.750inches $\pm$ 0.010           | 0.760<br>0.740 |      |                  |
| 2       | Clamp       | 6.786inches $\pm$ 0.010           | 6.796<br>6.776 |      |                  |
| 3       | Clamp       | 7.586inches $\pm$ 0.010           | 7.596<br>7.576 |      |                  |
| 4       | Clamp       | 0.063inches $\pm$ 0.010           | 0.073<br>0.053 |      |                  |
| 5       | Clamp       | 0.257inches<br>+ 0.006<br>- 0.001 | 0.263<br>0.256 |      |                  |

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